

Rush Feb 10

Work Order ID 78995

\*78995\*

Page 1

January-18-12 8:39:38 AM

Item ID: D4095-043 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Wearplate Assembly  
Start Date: 18/01/2012 Start Qty: 10.00 \*10\* Cust Item ID:  
Required Date: 01/02/2012 Req'd Qty: 10.00 \*10\* Customer:  
Reference:

Approvals: Process Plan: M.L.J. Date: 12/01/12 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4095	B								

100		0.00							
-----	--	------	--	--	--	--	--	--	--

\*100\* FLOW WATER JET

Waterjet Memo 0.00 B12-2-1

FLOW CNC Waterjet 1-Cut as per Dwg (D4095-3)

Dwg Rev: B (10)

Prog Rev: B

2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

\*110\* QC Memo 0.00 B12-2-1

Quality Control

120	QC8- Inspect parts - second check	0.00							
-----	-----------------------------------	------	--	--	--	--	--	--	--

\*120\* QC Memo 0.00 S1762/a

Quality Control (XIB)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*78995\***

Page 2

**\*N900040100\***

```

Setup  Start  *NS1*
      Stop  *NS2*

```

<b>Start Date:</b> 18/01/2012	<b>Start Qty:</b> 10.00	<b>*10*</b>
<b>Required Date:</b> 01/02/2012	<b>Req'd Qty:</b> 10.00	<b>*10*</b>

**Cust Item ID:**  
**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 78995

**\*78995\***

Page 3

January-18-12 8:39:38 AM

Item ID: D4095-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearplate Assembly  
 Start Date: 18/01/2012 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 01/02/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00 0.00		8.26.3/29					
170 <b>*170*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		8.26.3/29		(40)			
180 <b>*180*</b> HandFinish Hand Finishing	Hand Finishing COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: 120858	0.00 0.00				12-3-29		(10)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 78995

**\*78995\***

Page 4

January-18-12 8:39:38 AM

Item ID: D4095-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearplate Assembly  
 Start Date: 18/01/2012 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 01/02/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
									10x d HU 12/03/30 COUNTED & MEASURED
200 <b>*200*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>F2.1</u>  Memo	0.00  0.00							
									10x d HU 12/03/30 COUNTED & MEASURED
210 <b>*210*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							
									12/3/30 DJ C212103/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

January-18-12 8:39:42 AM

Page 1

Work Order ID: 78995

\*78995\*

Parent Item: D4095-043

\*D4095-043\*

Parent Item Name: Wearplate Assembly

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	141.8300	2.275	23.94737			

\*M304S16GA\*

304/316 Sheet .063

\*\*

B12-2-1

Location

Loc Qty

Loc Code

MAT020

141.83

119346

5.5

119653

40.33

120243

96

~~119653~~  
120243

(C)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 78995
<b>Description:</b> Wearplate		<b>Part Number:</b> D4095-3
<b>Inspection Dwg:</b> D4095	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.192	2		V KB02	
0.300	+/-0.010	.301	6		V	
0.300	+/-0.010	.302	2		V	
2.432	+/-0.010	2.438	2		V	
3.227	+/-0.010	3.228	2		V	
4.06	+/-0.030	4.052	2		V	
2.50	+/-0.030	2.502	2		V	
4.98	+/-0.030	4.983	2		V	
8.43	+/-0.030	8.423	6		Prow 502	
11.50	+/-0.030	11.50	2		T KB01	
21.750	+/-0.010	21.750	2		T	
3.500	+/-0.010	3.500	2		V	
12.22	+/-0.030	12.22	2		T	
6.000	+/-0.010	6.000	4		T	
12.100	+/-0.010	12.100	2		T	
21.00	+/-0.030	21.00	2		T	
30.000	+/-0.010	30.00	1		T	
36.000	+/-0.010	36.00	6		T	
38.88	+/-0.030	38.88	2		T	
0.063	+/-0.010	.060	2		V	

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Preliminary Approval:</b>
<b>Date:</b> 12-2-2	<b>Date:</b> 12/02/02	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-043	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	AA

UNCONTROLLED COPY  
SUBSTITUTION PROHIBITED  
WITHOUT APPROVAL

78995 M.C.J

12/01/18

D4095-1  
WEARPLATE

**D4095-041 WEARPLATE ASSEMBLY**

PLUS ONE  
ROCKGUARD

D4095-3  
WEARPLATE

**D4095-043 WEARPLATE ASSEMBLY**

D4095-5  
WEARPLATE

**D4095-045 WEARPLATE ASSEMBLY**

**D4095-041/-043/-045/-047/-049/-051 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)

PLUS ONE  
ROCKGUARD

2

RELEASED  
2011-10-31

PLUS ONE  
ROCKGUARD

2

B	REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3; ADDED D4095-5/-7/-9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED	AP		
MFG. APPR.	AP		
APPROVED	AP		
DE APPR.	AP		
DATE	11.10.18		

**DART AEROSPACE USA, INC**  
KENT, WA

DRAWING NO. D4095  
REV. B  
SHEET 1 OF 8

TITLE WEARPLATE  
SCALE NTS

COPYRIGHT © 2010 BY DART AEROSPACE USA, INC  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

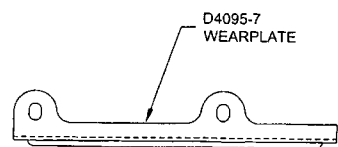
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

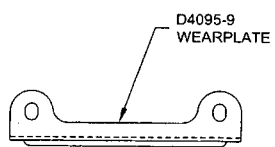
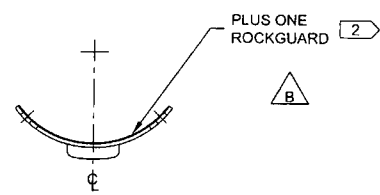
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

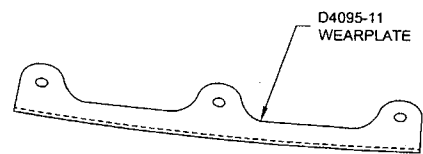
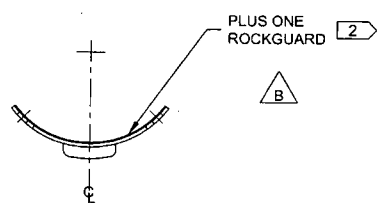
48995



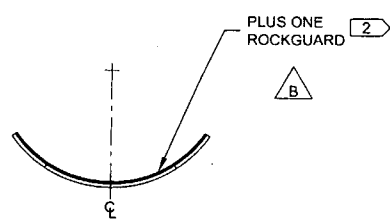
**D4095-047 WEAR PAD ASSEMBLY**



**D4095-049 WEAR PAD ASSEMBLY**



**D4095-051 WEARPAD ASSEMBLY**



RELEASED  
2011-10-31  
JMP

DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO. D4095	REV. B
MFG. APPR.	10	SHEET 2 OF 8	
APPROVED	10	TITLE WEARPLATE	SCALE NTS
DE APPR.	10	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	
DATE	11.10.18	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

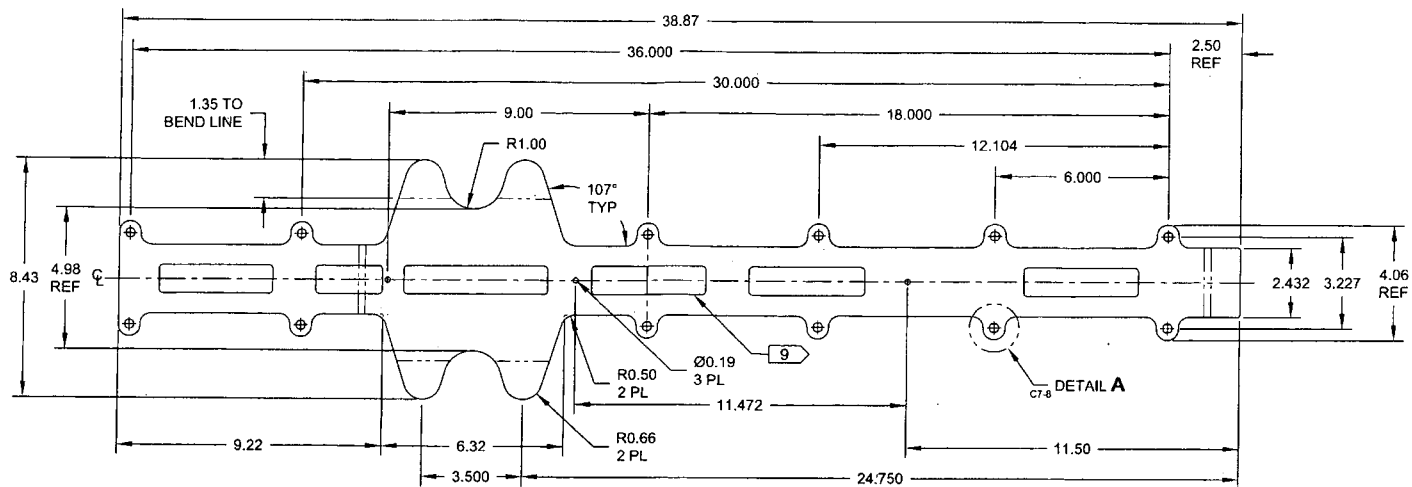
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

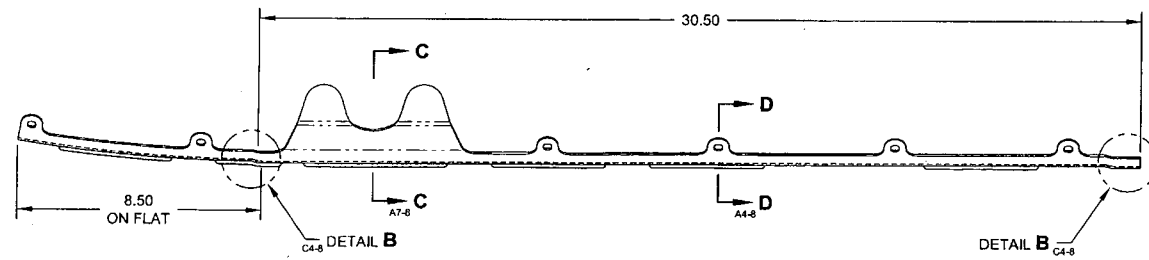
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

70995



**D4095-1F FLAT PATTERN** 1



**D4095-1 BENDING DETAIL**  
(MAKE FROM D4095-1F)

**D4095-1/-1F/-3/-3F/-5/-5F/-7/-7F/-9/-9F/-11/-11F NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240  
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C

RELEASED  
2011-10-31

DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4095	SHEET 3 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	11.10.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

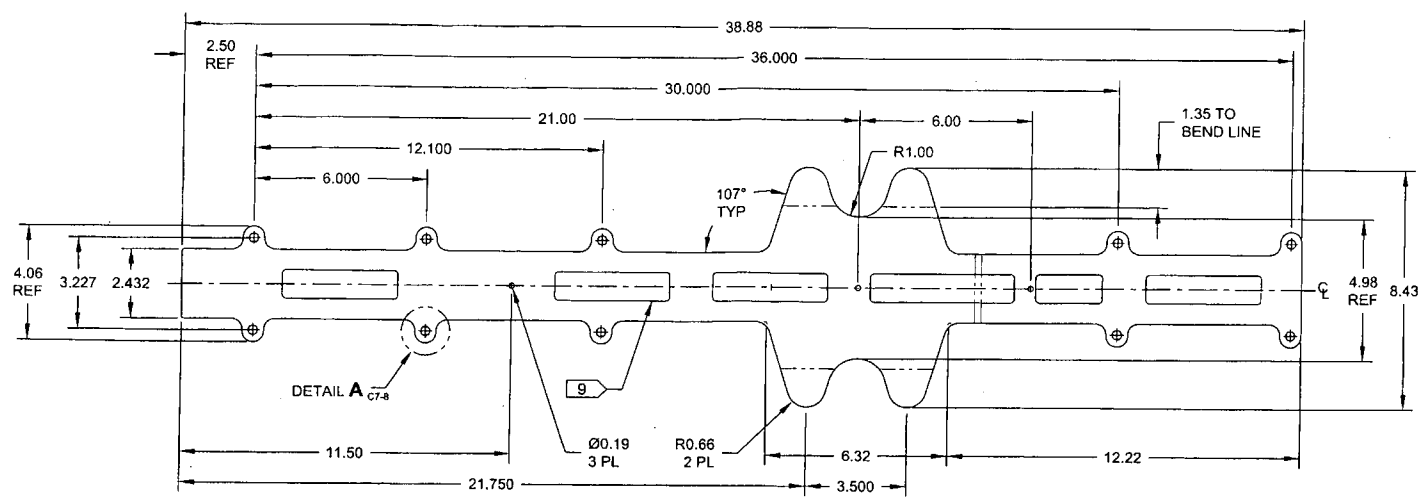
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

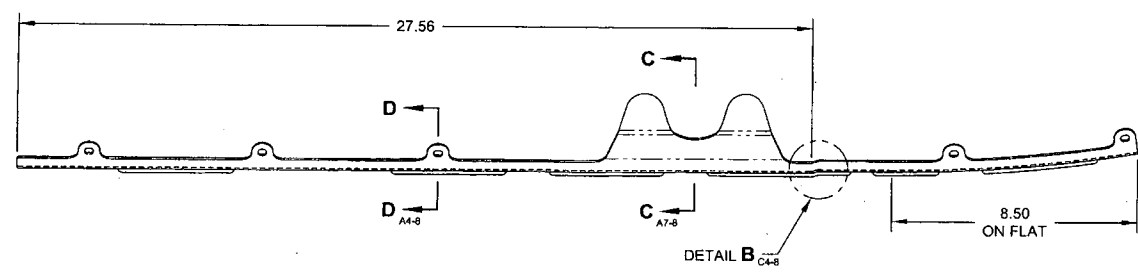
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

78995



**D4095-3F FLAT PATTERN**



**D4095-3 BENDING DETAIL**  
(MAKE FROM D4095-3F)

RELEASE  
2011-10-31

DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4095	SHEET 4 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEARPLATE	NTS
DATE	11.10.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

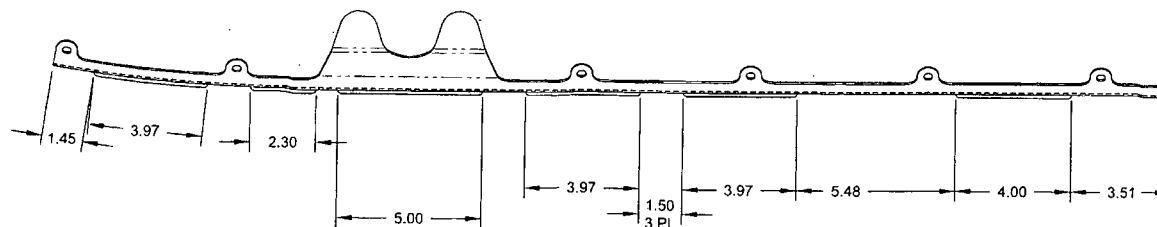
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

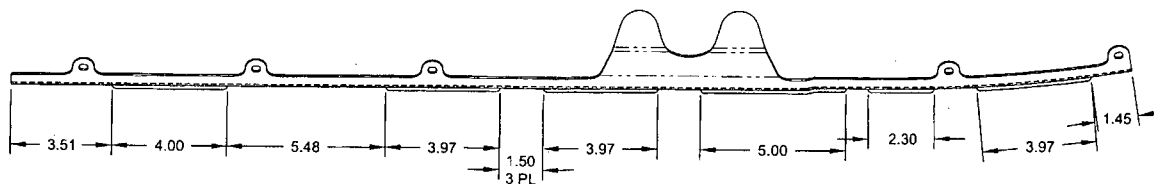
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

78995



**D4095-1 WELDING DETAIL**



**D4095-3 WELDING DETAIL**



RELEASED  
2011-10-31  
MP

DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4095	SHEET 5 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEARPLATE	NTS
DATE	11.10.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

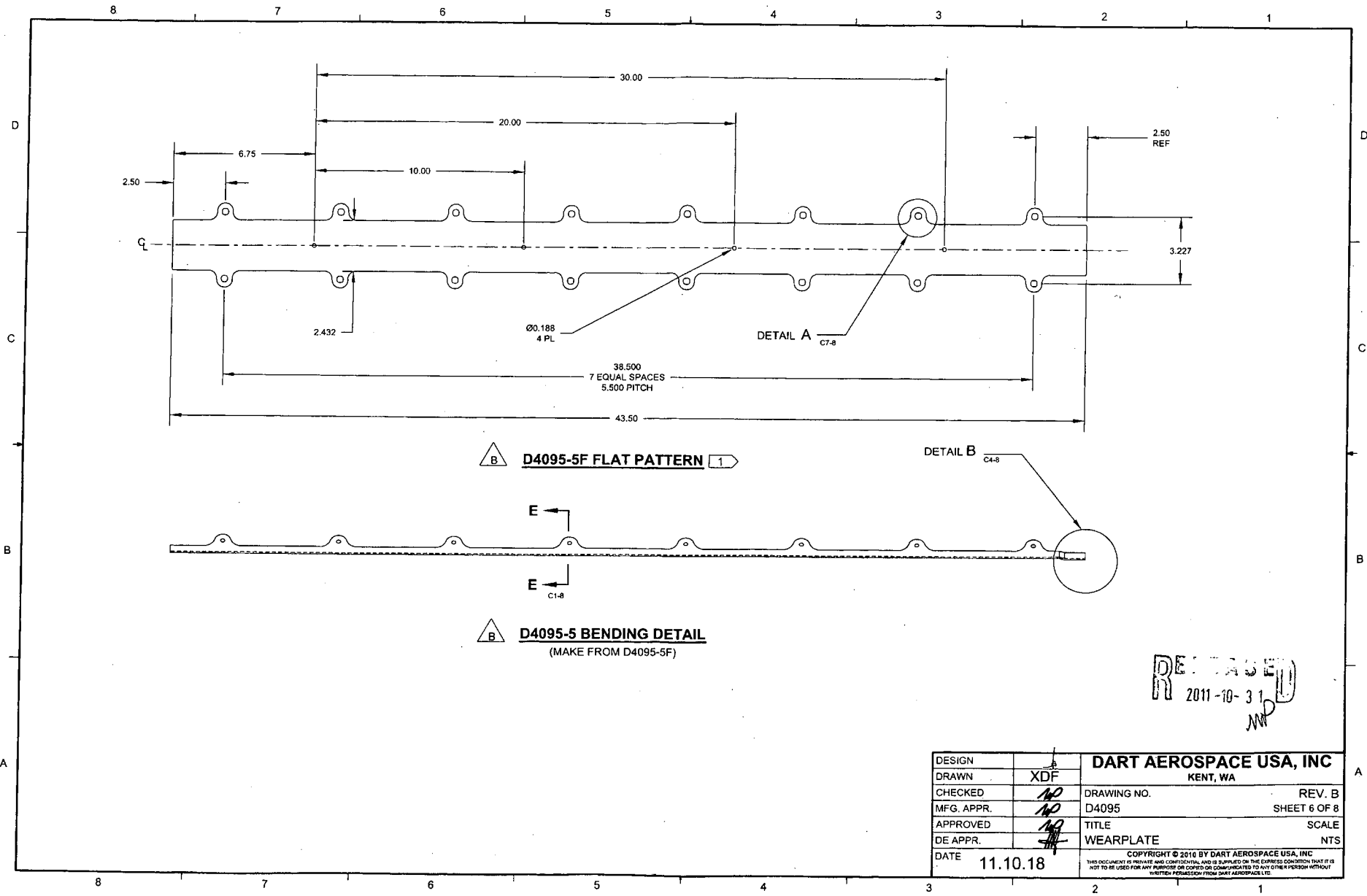
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

78995



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

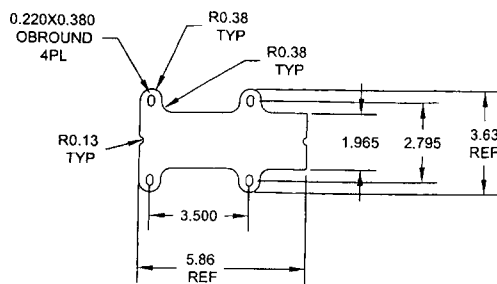
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

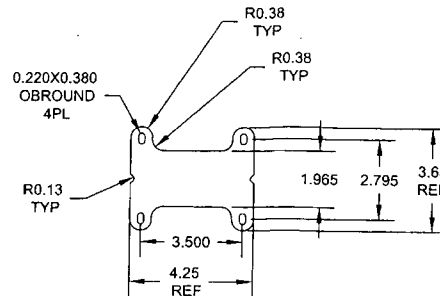
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

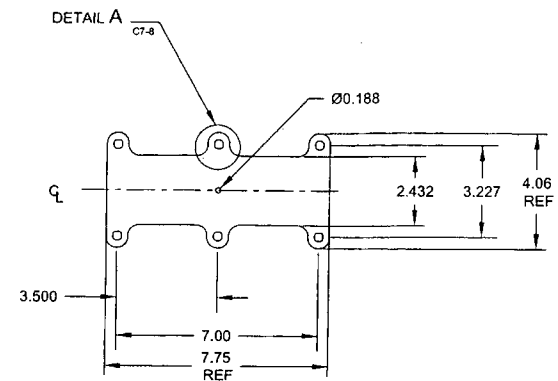
78995



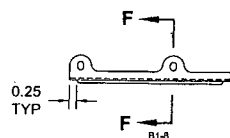
**D4095-7F FLAT PATTERN**



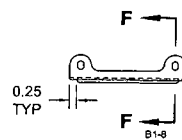
**D4095-9F FLAT PATTERN**



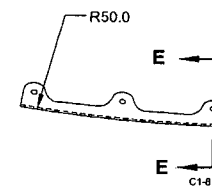
**D4095-11F FLAT PATTERN**



**D4095-7 LONGITUDINAL BEND**  
(MADE FROM D4095-7F)



**D4095-9 LONGITUDINAL BEND**  
(MADE FROM D4095-9F)



**D4095-11 BENDING DETAIL**  
(MAKE FROM D4095-11F)

2011-10-31

DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED	NO	DRAWING NO.	REV. B
MFG. APPR.	NO	D4095	SHEET 7 OF 8
APPROVED	NO	TITLE	SCALE
DE APPR.	NO	WEARPLATE	NTS
DATE	11.10.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

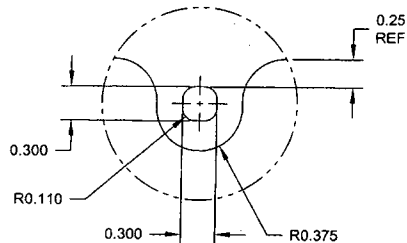
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

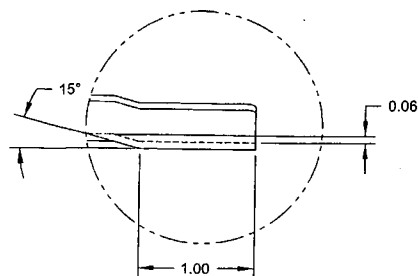
**NOTE:** Date & initial all entries

78995



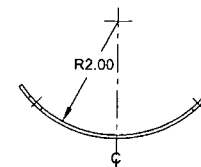
**DETAIL A: TAB DETAIL**

SCALE 4X  
C3-3  
C6-4  
D3-6  
D2-7



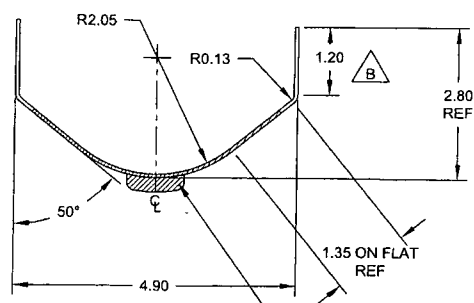
**DETAIL B: JOGGLE DETAIL**

SCALE 4X  
B2-3  
B5-3  
B3-4  
B2-6



**SECTION E-E**

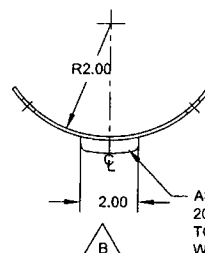
SCALE 2X  
B5-6  
B2-7



**SECTION C-C**

SCALE 2X  
B5-3  
B4-4

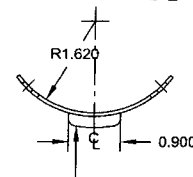
APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK



**SECTION D-D**

SCALE 2X  
B4-3  
B5-4

APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK



**SECTION F-F**

SCALE 2X  
B5-7  
B7-7

APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

RELEASED  
2011-10-31  
MP

DESIGN		<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.	AP	D4095	SHEET 8 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	WEARPLATE	NTS
DATE	11.10.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries